



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3294-1
Job Sheet 187007



Part No: D3294-1

Job Qty: 8 ea

Part Name: Bracket For Interior Window For -115



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 12/21/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP A 04.08.24 New issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	12/21/18	12/21/18	0.00	2.56	Waterjet - Flow		SC 18/11/30
110	QC	8 pcs	12/21/18	12/21/18	0.00	0.00	QC2 Waterjet-1		SC 18/11/30
120	QC	8 pcs	12/21/18	12/21/18	0.00	0.00	QC8-2		38 DAS
130	Brake NC	8 pcs	12/21/18	12/21/18	0.08	1.10	Brake NC 1		DAS 9-89 30
140	QC	8 pcs	12/21/18	12/21/18	0.00	0.00	QC5		38 8-89
150	HandFinish	8 pcs	12/21/18	12/21/18	0.00	0.61	HandFinish1		D.B. 18/12/11
160	QC	8 pcs	12/21/18	12/21/18	0.00	0.00	QC7-2		38 DAS
170	Small Fab	8 pcs	12/21/18	12/21/18	0.00	1.25	Small Fab-3		9-89 36 DAS
180	QC	8 pcs	12/21/18	12/21/18	0.00	0.00	QC5		JAN 23 2019 68
190	Powdercoat	8 pcs	12/21/18	12/21/18	0.00	0.35	Powdercoat4		19-01-24 38
200	QC	8 pcs	12/21/18	12/21/18	0.00	0.00	QC3		38 8-89
210	Packaging	8 pcs	12/21/18	12/21/18	0.00	0.00	Packaging3-1	5-135	JAN 24 2019 9-0-10
220	QC21-SA	8 Ea	12/21/18	12/21/18	0.00	0.00	QC21		JAN 24 2019 21

Part Op 100 - 1-Cut as per Dwg D3294 CUT File D3294-3 Dwg Rev: D Prog Rev: D *grain direction on a 45 deg as Descriptions: per dwg** 2-Deburr if necessary

130 - 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)

170 - 1-Install D3294.5 doubler to D3294-3 bracket with rivets as per dwg. D3294

190 - Start Time: 8:32 Oven Temperature: 375 Finish Time: 9:00

M 138839.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	14.4000 sf (1.8 ea)	100-Waterjet - Flow - 1	510799
D3294-5	Doubler	8 Ea (1 ea)	170-Small Fab	5136070
MS20470AD4-5	Rivet, Universal Head	120 Ea (15 ea)	170-Small Fab	50498297

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	14	71	0
170-Small Fab	D3294-5	8	10	0
	MS20470AD4-5	120	801	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																											
Date : _____	Step #: _____	Description Work Order Deviation Completed By _____ Inspector / Supervisor _____ Approval _____ Coordinator _____ Approval _____																																																																																																																																																											
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Part: D3294-1
 Job No: 187007
 Serial No/Batch: S133544
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's
 Date: 11/20/18



Container No: S133544
 DART Aerospace
 1220 Aberdeen Street
 Markham, ON L3R 9V7
 CANADA
 TEL: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

QSI042) Approval

Part Specifications

Specifications could not be found.

Plex 11/23/18 1:40 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 187007
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.129	1		VSC	
Ø0.141	+0.005/-0.001	0.142	1		Tape	
6.708	+/-0.010	6.710	1			
1.118	+/-0.010	1.115	1			
5.590	+/-0.010	5.589	1			
1.118	+/-0.010	1.117	1			
13.563	+/-0.010	13.565	1			
1.043	+/-0.010	1.045	1			
0.625	+/-0.010	0.625	1			
0.325	+/-0.010	0.328	1			
0.300	+/-0.010	0.303	1			
0.400	+/-0.010	0.402	1			
6.000	+/-0.010	6.001	1			
1.000	+/-0.010	1.002	1			
17.124	+/-0.010	17.125	1			
16.13	+/-0.030	16.132	1			
7.27	+/-0.030	7.268	1			
11.97	+/-0.030	11.965	1			
8.37	+/-0.030	8.372	1			
20.05	+/-0.030	20.05	1			
12.98	+/-0.030	12.98	1			
14.59	+/-0.030	14.59	1			
11.66	+/-0.030	11.66	1			
0.080	+/-0.010	0.079	1			

Measured by: SC	Audited by: 38	Preliminary Approval:
Date: 18/11/20	Date: DEC 05 2018	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	